

Work Order ID 147267

Wednesday, June 08, 2016 2:25:45 PM

147267

Page 1

Item ID: D412-786-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Hardpoint Installation
 Start Date: 6/20/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/24/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: JUN 09 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-786-1	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-786-013 chg001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
6
9-89
JUN 16 2016
habe

DAS
28
9-89

JUN 27 2016

JUN 27 2016

DAS
27
9-89
JUN 27 2016

DAS
28
9-89

JUN 27 2016

JUN 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 147267

Wednesday, June 08, 2016 2:25:45 PM

147267

Page 2

Item ID: D412-786-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Hardpoint Installation

Start Date: 6/20/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

DAS
28
9-89

DAS
27
9-89

Identify and pack for shipping as per PPP D412-786-013

Location: _____

PPP Rev: _____

PPP 147258

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

JUN 27 2016

16/6/27

SH 16/27/16.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 147267

147267

Parent Item: D412-786-013

D412-786-013

Parent Item Name: Fwd Hardpoint Installation

Start Date: 6/20/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-04-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3870-041 Hardpoint, Fwd LH DAS 28 9-89		Manufactured	No				Each	2.0000		1			
D3870-041									**			DAS 6 9-89	DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST056				2					
				144561				2					
D3870-042 Hardpoint, Fwd RH DAS 28 9-89		Manufactured	No				Each	2.0000		1			
D3870-042									**				
				<u>Location</u>				<u>Loc Qty</u>					
				ST056				2					DAS 6 9-89
				144562				2					DAS 27 9-89
D3870-5 Mount, Fwd Upper DAS 28 9-89		Manufactured	No				Each	4.0000		1			
D3870-5									**				
				<u>Location</u>				<u>Loc Qty</u>					
				ST056				4					DAS 6 9-89
				121992				4					DAS 27 9-89
D3871-1 Doubler DAS 28 9-89		Manufactured	No				Each	3.0000		1			
D3871-1									**				
				<u>Location</u>				<u>Loc Qty</u>					
				ST056				3					DAS 6 9-89
				111907				3					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 2

Work Order ID: 147267

147267

Parent Item: D412-786-013

D412-786-013

Parent Item Name: Fwd Hardpoint Installation

Start Date: 6/20/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D3871-2

Manufactured No

Each

3.0000

1

9-89 DAS 27 9-89

D3871-2

Doubler

DAS
28
9-89

Location

Loc Qty

Loc Code

ST056

3

111908

3

MS21042L3

Purchased

No

Each

1,907.000

10

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

56

m133790

56

GA

269

m133790

3

m134360

266

OVER007

600

m134754

600

ST303

982

m134039

12

m134634

170

m134943

800

MS27039-1-11

Purchased

No

Each

175.0000

8

MS27039-1-11

Screw

Location

Loc Qty

Loc Code

GA

20

125654

13

9662

7

over006

50

m134738

50

ST280

105

124326

105

DAS
28
9-89

DAS
6
9-89

DAS
27
9-89

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Shop Packet Print

JUN 23 2016
Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER :									

Picklist Print

Wednesday, June 08, 2016 2:25:48 PM

Page 3

Work Order ID: 147267

147267

Parent Item: D412-786-013

D412-786-013

Parent Item Name: Fwd Hardpoint Installation

Start Date: 6/20/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-12

Purchased

No

Each

99.0000

1

MS27039-1-12

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

over006

50

m134294

50

ST280

49

m133988

49

MS27039-1-14

Purchased

No

Each

759.0000

1

MS27039-1-14

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

94

120449

94

over006

500

124326

500

ST280

165

124326

165

NAS1149D0332J

Purchased

No

Each

1,258.000

10

NAS1149D0332.J

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

22

m134502

22

ST260a

1200

m134738

600

m134848

600

ST264

30

m134502

30

DAS
27
9-89

JUN 23 2016

DQA: _____ Date: _____



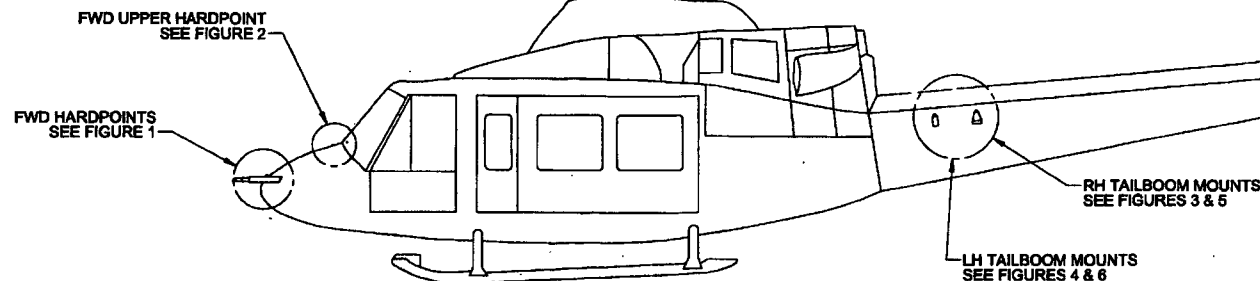
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐											

REFERENCE ONLY



D412-786-011/-021 HARDPOINT KIT

QTY -011	QTY -013	QTY -015	QTY -021	QTY -025	PART NUMBER	DESCRIPTION
X					D412-786-011	HARDPOINT KIT
1	X		1		D412-786-013	FWD HARDPOINT KIT
1		X			D412-786-015	TAILBOOM MOUNT KIT
			X		D412-786-021	HARDPOINT KIT
			1	X	D412-786-025	TAILBOOM MOUNT KIT
		1			D3866-041	TAILBOOM MOUNT
		2			D3866-043	TAILBOOM MOUNT
	1				D3870-041	FWD LH HARDPOINT
	1				D3870-042	FWD RH HARDPOINT
	1				D3870-5	FWD UPPER HARDPOINT
	1				D3871-1	DOUBLER
	1				D3871-2	DOUBLER
				1	D4950-041	TAILBOOM MOUNT
				2	D4950-043	TAILBOOM MOUNT
	10	12		12	MS21042L3	NUT
	8	12		12	MS27039-1-11	SCREW
	1				MS27039-1-12	SCREW
	1				MS27039-1-14	SCREW
	10	24		24	NAS1149D0332J	WASHER

INSTALLATION	WEIGHT	LONGITUDINAL		LATERAL	
		ARM	MOMENT	ARM	MOMENT
D412-786-011 HARDPOINT KIT	0.58 LBS 0.26 KG	164.67 IN 4.18 M	95.51 IN-LB 1.09 KG-M	-1.25 IN -0.03 M	-0.73 IN-LB -0.008 KG-M
D412-786-013 FWD HARDPOINT KIT	0.22 LBS 0.10 KG	-13.55 IN -0.34 M	-2.88 IN-LB -0.03 KG-M	2.36 IN 0.06 M	0.52 IN-LB 0.008 KG-M
D412-786-015 TAILBOOM MOUNT KIT	0.36 LBS 0.16 KG	273.58 IN 6.95 M	98.49 IN-LB 1.11 KG-M	-3.47 IN -0.09 M	-1.25 IN-LB -0.01 KG-M
D412-786-021 HARDPOINT KIT	0.64 LBS 0.29 KG	164.67 IN 4.18 M	105.39 IN-LB 1.21 KG-M	-1.25 IN -0.03 M	-0.08 IN-LB -0.01 KG-M
D412-786-025 TAILBOOM MOUNT KIT	0.42 LBS 0.19 KG	273.58 IN 6.95 M	114.90 IN-LB 1.32 KG-M	-3.47 IN -0.09 M	-1.46 IN-LB -0.02 KG-M

NOTES:

- 1) D412-786-011/-021 HARDPOINT KIT REQUIRED ON 412/412EP AIRCRAFT UTILIZING D412-895-011 BLADE FOLDING KIT WHERE WIRE STRIKE COMPATABILITY IS REQUIRED
- 2) D412-786-021 HARDPOINT KIT REQUIRED ON AIRCRAFT EQUIPPED WITH BLR TAILBOOM STRAKE KIT
- 3) TOUCH UP DRILLED HOLES WITH ALODINE PER THE AIRCRAFT MAINTENANCE MANUAL
- 4) TORQUE FASTENERS AS FOLLOWS: 10-32; 20-25 IN-LBS
- 5) PRIME AND PAINT HARDPOINTS TO MATCH AIRCRAFT PAINT SCHEME PER AIRCRAFT MAINTENANCE MANUAL

C	MODIFY D3870-5 INSTALLATION INSTRUCTION, ADD TO NOTE 2, SH 3 AND CLARIFY/CORRECT VIEW C-C (ZN A8-3, C3-3)	DB	14.04.28
B	ADD -021/-025 KITS, SHEETS 6 & 7	DB	13.10.17
A	NEW ISSUE	DB	09.01.14
REV	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	D412-786-1	SHEET 1 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HARDPOINT KIT INSTALL	NTS
DATE	14.04.28	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Work Order ID 147267

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147267

Page 1

Item ID: D412-786-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Hardpoint Installation

Start Date: 6/20/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/24/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D412-786-1	C

100	Document Control	0.00							
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100

DC

DOCUMENT CONTROL

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile and create labels per PPP D412-786-013 chg001

MCS JUN 23 2016

110	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

110

Packaging

Memo

0.00

Packaging

120	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC

Memo

0.00

Quality Control